

Work Order ID 118444

\*118444\*

Page 1

Tuesday, September 02, 2014 3:37:03 PM

Item ID: D206-642-511

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Stop \*NS2\*

Start Date: 8/28/2014 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 8/29/2014 Req'd Qty: 1.00 \*1\*

Customer: CEDWA01

Reference: RMA RA111838 - RETURN

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT CANADA K6A 1K7				TO APPROVAL # 09-09 TEL: 1-818-632-5200	
P/N	D206-642-511	C/C	CHG004		
DESC.	Float Skidtube LH	S/C	SH98-4		
LOT	B105650	S/C	SA00475SE		
MODEL	206L/L1/L3/L4/407	S/C			
PATENTS US 5,573,513; CA 2,222,184 EUROPEAN NO. 0 482 855				MADE IN CANADA	

Approvals: Process Plan: WVF Date: 11-09-02 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-642	Q

100 0.00

\*100\*

QC

Quality Control

Memo

INSPECT RA 111838  
D206-642-511 X 1 B105650  
KIT IS COMPLETE  
ID AND STOCK UNDER NEW BATCH NUMBER

110

Identify as per dwg & Stock Location: 073 0.00

\*110\*

Packaging

Memo

Packaging

120

QC21- Final Inspection - Work Order Release 0.00

\*120\*

QC

Quality Control

Memo

OCT 07 2014

DAS  
06  
2-89

CHG 004

14/10/9  
14-10-9

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# Picklist Print

Tuesday, September 02, 2014 3:37:01 PM

Page 1

Work Order ID: 118444

**\*118444\***

Parent Item: D206-642-511

**\*D206-642-511\***

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 8/28/2014

Required Date: 8/29/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM  
 IPP Rev:C 07-02-23 As per IIN D206-642 Rev K JLM  
 IPP rev D 07.06.06 added K642-511 EC  
 IPP Rev:E 07-12-05 ECN 1080p Rev L DD verified by: IPP REV:F  
 13.09.06 CHG005/ ECN13-634 DD VERF:JLM IPP REV:G 14.04.28  
 AS PER ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-511		Manufactured	No				Each	14.0000		1			

**\*D206-642-511\***

**\*\***

Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Location	Loc Qty	Loc Code
FG	6	
105640	1	
109870	1	
112852	1	
116363	1	
121736	1	
89627	1	
FG073	8	
109645	1	
119188	1	
119197	1	
119198	1	
121734	1	
121735	1	
121737	1	
121738	1	

1x 105630  
mf  
14-9-02

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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# RA 111838

Received @ Dart August 6<sup>th</sup>, 2014  
Inspected@ Dart August 11<sup>th</sup>, 2014

CUSTOMER: BELL HELICOPTERS  
CUSTOMER CONTACT: CYNDI BERNDIT  
SHIPPED FROM: PINEY FLATS TN, USA

## Instructions for RA 111838

- See attached pictures for damaged boxes
- **D206-667-103 B97423**
  - Kit is complete
  - Needs new labels and paperwork's
  - Is at current CHG #006
  - Return to stock under new batch #
- **D206-667-203 B91700**
  - Kit is complete
  - Needs new labels and paperwork's
  - Is at current CHG #004
  - Return to stock under new batch #
- **D206-642-511 B105650**
  - Kit is complete
  - Needs new labels and paperwork's
  - Is at current CHG #004
  - Return to stock under new batch #
- **D206-642-512 B106984**
  - Tube is damaged
  - Needs aft cap D2646 and mounting hardware
  - Kit is complete
  - Needs new labels and paperwork's
  - Is at current CHG #004
  - Return to stock under new batch #
- **D206-628-023 B88698**
  - Step is correct (LH re inspected)
  - Kit is complete
  - Needs new labels and paperwork's
  - Is at current CHG #003
  - Return to stock under new batch #
- **D206-628-024 B88699**
  - Step is correct (RH re inspected)
  - Kit is complete
  - Needs new labels and paperwork's
  - Is at current CHG #003
  - Return to stock under new batch #

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Supplier									
Training									
Transport									
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### FAULT CATEGORY

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**Time Estimate** = 6 HOURS

**Departments Required:** Packaging & finishing

**Pictures Attached** = Yes

**QTY INSPECTED** = D206-667-103 B97423 CHG006  
D206-667-203 B91700 CHG006  
D206-642-511 B105650 CHG004  
D206-642-512 B106984 CHG004  
D206-628-023 B88698 CHG003  
D206-628-024 B88699 CHG003

**THIS INSTRUCTION SHEET MUST  
BE ATTACHED TO THE  
RESTOCKING WORK ORDER AT  
ALL TIMES!!!!**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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